CAN AN UNLICENSED PERSON MAKE A MACHINE GUN?

Generally, NO. But, in the event that documentation can be provided, along with the application to make a machine gun, which establishes that the weapon is being made for distribution to; 1-The United States or any department or agency thereof or 2- A state, or department , agency or political subdivision thereof. Then the individual would be permitted to make a machine gun.

Any machine gun is subject to the NFA and the possession of an unregistered machine gun could subject the possessor to criminal prosecution.

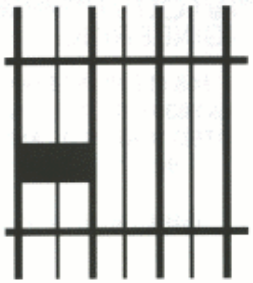


TABLE OF CONTENTS

HISTORY.....6

NOMENCLATURE.....8

CARTRIDGE.....9

DISASSEMBLY.....10

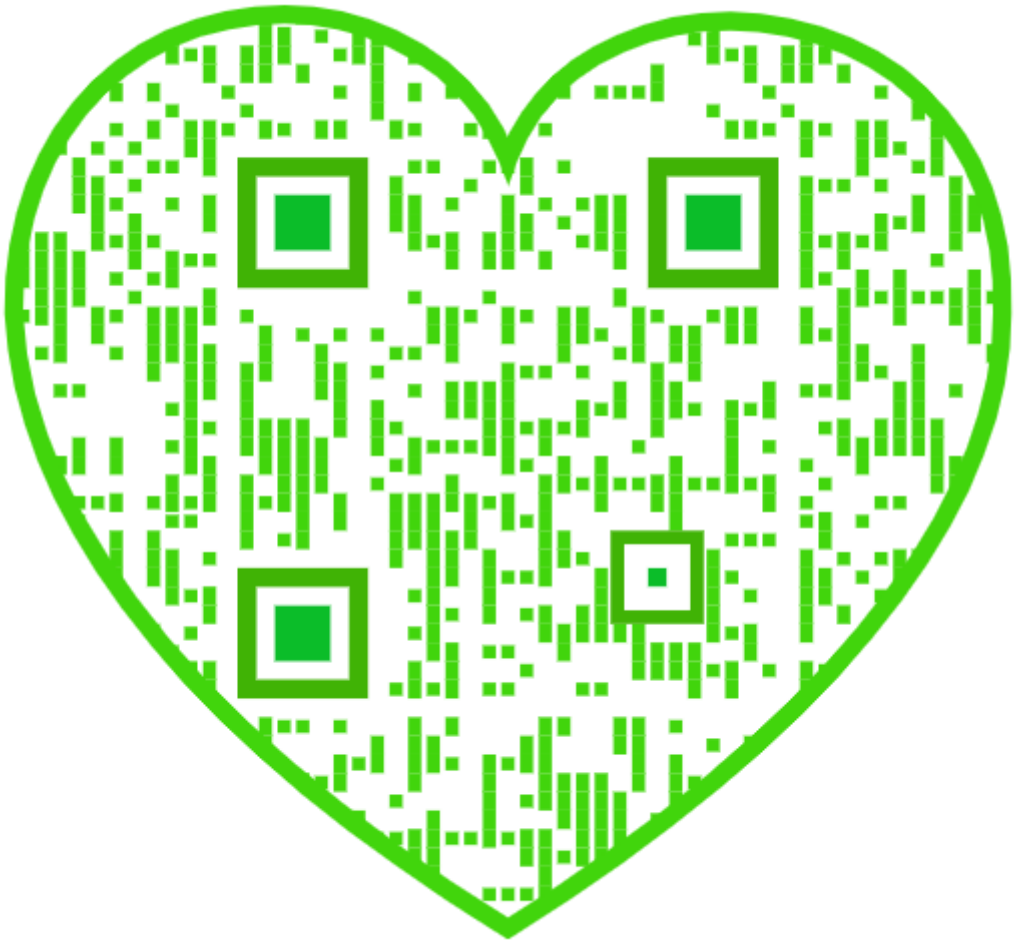
TRIGGER GROUP DISSASSMBLY.14

UNDERSTANDING THE TRIGGER GROUP FUNCTION.....15

HAMMER.....19& 25

BLOCKING THE SEAR DISCONNECTOR.....20

MINUTE-MAN FAST & EASY WIRE CONVERSION.....29 & 29



HISTORY

The SKS gets it's name from the following Russian factories: Samozaryadnyi Karabin Simonova.

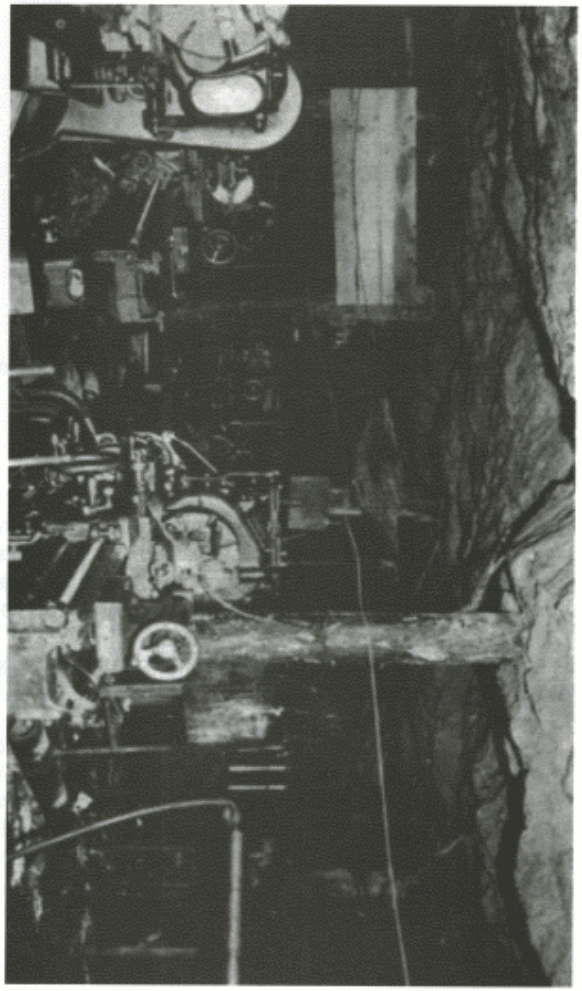
In World War 2 the Russian army found an immediate need for a medium cartridge. They wanted to counter the very successful German light machine gun. It needed to have an effective range of up to 300 meters.

Russian engineers went to work and developed the 7.62 X 39mm, very similar to the German cartridge. The Russian armory gunsmiths came up with a durable, easy to function, easy to manufacture and reliable rifle. The tilt bolt (a variation of an antitank rifle) is still used in today's SKS model assault rifles. The SKS sights were also copied onto the AK-47.

Many different versions of the SKS were made at various factories around the world. In China it is known as the Type-56, in Yugoslavia it is a Type M-59, etc. Although now it is only used by Honor Guards at the Tomb of the Unknown Soldier, and a few Russian party buildings.

Today most of the SKS's are manufactured by the Chinese. It is designed with a shorter stock, to fit the smaller Asian physique, a longer barrel and a few other small variations, it is still just a copy of the original Russian SKS.

Millions of SKS guns were given by China and Russia to Vietnam and they were found to be very rugged, accurate and reliable guns. In order to stop corrosion in the tropical regions, such as Vietnam, a special fiberglass stock was also manufactured.



A DEEP UNDERGROUND VIETNAMESE MACHINE SHOP, SAFE FROM AMERICAN BOMBERS. THIS SHOP MANUFACTURED SMALL ARMS PARTS

NOMENCLATURE

WEIGHT: 8.8 lbs.
LENGTH: 40.2 Inches.
BARREL: 20.5" with 4 groves and a right hand twist.
CHROME LINED BORE: .311 to .313 grove diameter.
MAGAZINE: 10 round box, fixed to receiver.
MUZZLE VELOCITY: 2250 Feet Per Second.
CALIBER: 7.62 X 39 MM (M43)
SYSTEM OF OPERATION: Short stroke gas piston.
METHOD OF LOCKING: Positively locked tilting bolt.
SIGHTS: (Front) Protected post adjustable for windage and elevation. (Rear) "U" notch tangent adjustable for elevation from 100 to 7 degrees.
FINISH: Salt Blued with polished bolt and carrier, and varnished wood.

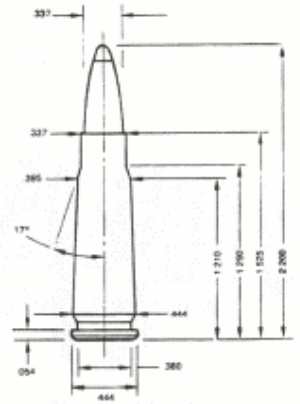
There are many accessories available to custom modify your SKS into a true hunting rifle. With a Monte Carlo stock, a scope and a five shot fixed box magazine, your SKS will look at home on the wall of any deer camp.

If shooting excitement is what you want, try a folding stock with a detachable 30 round clip and muzzle break.

Most military rifle designs are now incorporating a 3 shot burst to stop the inaccurate spraying of your target. You should note that in Vietnam statistics showed American troops fired 200,000 rounds for each confirmed kill. This clearly shows automatic fire is not needed in today's high-tech military.

CARTRIDGE

The 7.62x39M cartridge was designed in the Soviet Union in 1943. Designated model 43 or M43, it is now used in most Communist block countries, including Red China. Because of the wide use in SKS, AKS, AK47 assault rifles, and RPD light machine guns it is often called the worlds most popular cartridge.



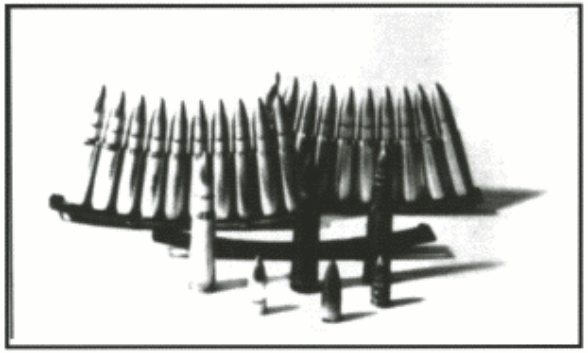
It has a bullet weight of 110 to 150 grains and a bullet diameter of .308 to .312 and it travels at 2250 fps. It is easy to see the wide range of uses this rifle can have.

Generally the heavier bullet weight of 130 grains seems to target closer and work the action better at faster fire rates than the lighter 110 grains.

Over 38 million 7.62x39 rifles have been produced in Russia alone, with all the other countries now selling warehoused rifles. The ammo and parts are cheap and easy to find.

You should note the 7.62x39 ammunition from China and many other Communist block countries will sometimes have copper plated, steel core bullets instead of copper coated lead, and copper plated steel cases instead of brass.

This steel bullet will have extremely powerful penetrating capabilities and will be economical to shoot, although these cases are not reloadable. The "armor piercing" power could be of great benefit.

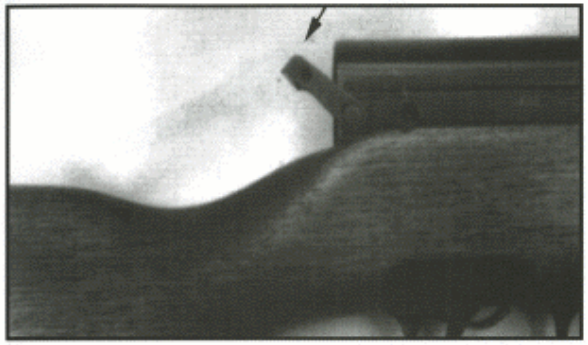


Millions of Americans have enjoyed the SKS and the cheap ammo available for it.

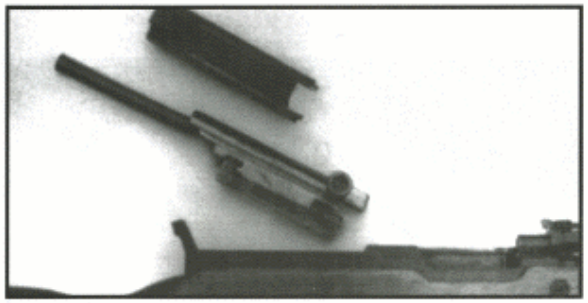
NOTE: you should clean your gun as soon as possible after each use, as cheap ammo is likely to be corrosive.

DISASSEMBLY

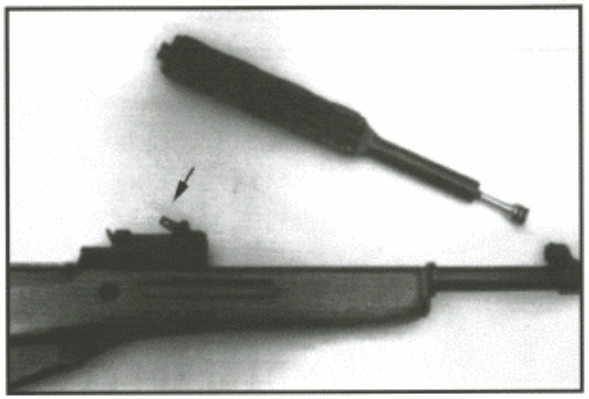
1) To remove the bolt, close bolt carrier and locate lever on right rear receiver. Lift up and draw out lever. You must close bolt to remove spring pressure from receiver cover.



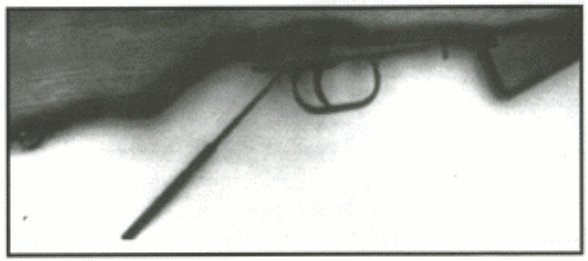
2) Slide receiver cover off, remove spring, slide bolt carrier to the rear and lift out. Draw bolt to the rear and lift out. Clean and inspect.



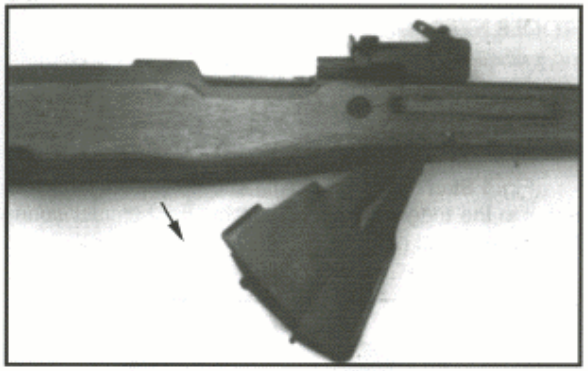
3.) To remove gas piston, locate lever on right rear sight block, lift until cam clears gas piston cylinder, lift out cylinder, clean and inspect.



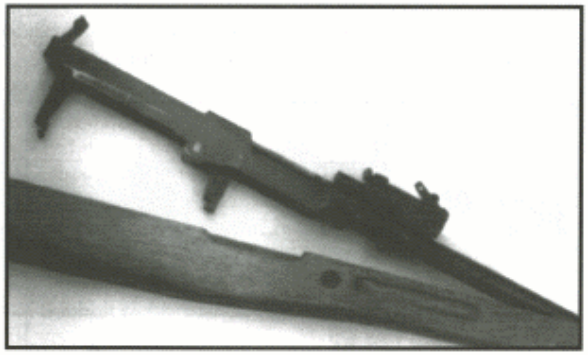
4.) To remove trigger group and magazine, the safety must be up or on safety, and the magazine opened. Locate the pin directly behind finger guard, use a screwdriver, your tool kit or even a bullet to press pin in, lift trigger group out.



5) Lift out magazine. Clean and inspect.



5) lift barrel & receiver from stock. Clean and inspect. Disassembly to this point should take 1/2 hour. Clean and inspect thoroughly.



TRIGGER GROUP DISASSEMBLY

TOOLS NEEDED: Safety glasses, hammer, 3/32 pin driver, and a disassembly block (at least 1" thick). Drill a 3/16" hole

Fig. 1 Start by drawing hammer back to clear pins from notch in the trigger frame, be careful, the hammer spring has a great deal of force.

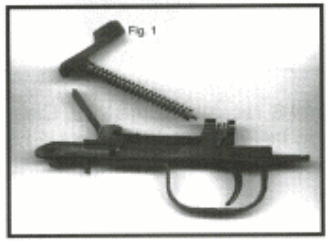


Fig. 2 Drive out magazine catch retaining pin, slide out magazine catch, remove spring, slide out sear.

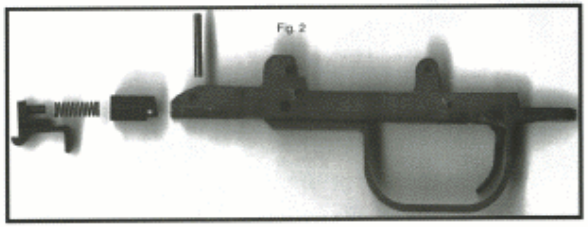
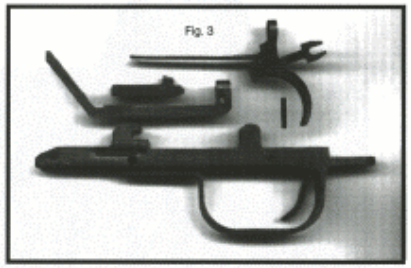


Fig. 3 Drive out bolt follower pin, lift out bolt follower and spring, drive out trigger pin, lift out trigger and sear disconnector and safety spring. Squeeze disconnector and lift out. Drive out safety lever pin, remove safety (safety removal is optional).



UNDERSTANDING TRIGGER GROUP FUNCTION

As you draw the bolt carrier back, the bolt will contact the hammer face, moving the hammer to the rear and compressing the hammer spring. As the hammer moves to the rear it will engage the bolt follower then the sear. Now release the bolt and bolt carrier forward to close. The bolt follower will hit the bolt and drop the sear disconnector into alignment with the sear and release the hammer catch, the sear now holds the hammer back. When the trigger is squeezed the sear disconnector will move forward, held in alignment by the bolt follower, it will contact the sear, driving the sear forward, releasing the hammer and firing the rifle.

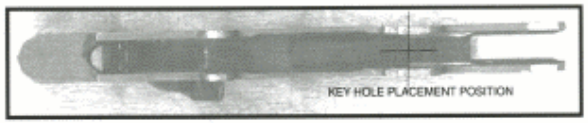
The bolt follower will not allow the hammer to be released until the bolt closes completely. The bolt will contact the bolt follower, putting it in contact with the sear disconnector and into alignment with the sear.

WARNING

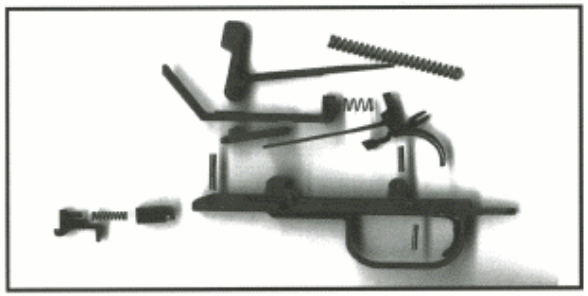
The Bureau of Alcohol, Tobacco and Firearms has ruled that it is illegal to modify any firearm so that it will fire automatically or to make parts which will make it fully automatic without their prior approval.

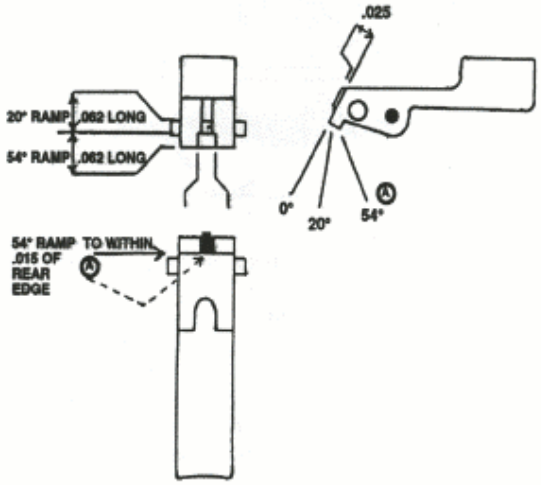
Note; This booklet is offered for it's educational and entertainment purposes only. We are not responsible nor are we liable for the illegal modifications of any firearm

You must stand the trigger group functions to understand this SKS conversion. View the sear disconnector and sear through a 3/16" hole just below the hammer pin.



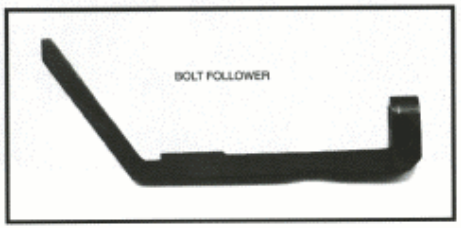
Note: The sear disconnector will move forward to contact the sear only when the bolt follower is in correct position (bolt closed) aligning the sear disconnector. With the trigger pulled back, note how the sear disconnector will be forced below the sear when the hammer is drawn all the way back. This is where the conversion studies begin. If the hammer cam is removed, the bolt follower will not force the sear disconnector down below the sear.





HAMMER

When the sear disconnector is not cammed down below the sear, the sear can't move to the rear to make contact with the hammer and hold it. It will make the bolt follower hold the hammer.

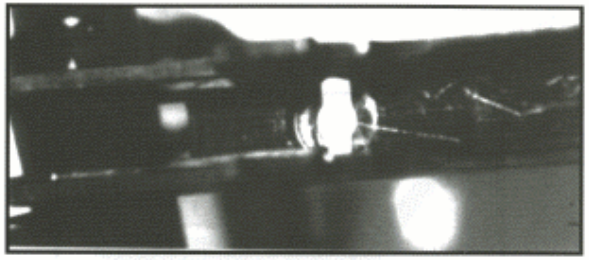


When the bolt closes, the bolt will contact the bolt follower, releasing the hammer and firing the rifle. This cycle will repeat until the trigger is released. When the trigger is released the sear will move to the rear, Contacting and holding the hammer, stopping the cycle. When the trigger is squeezed again the cycle will restart. Although this is the first method, it will not be completely reliable

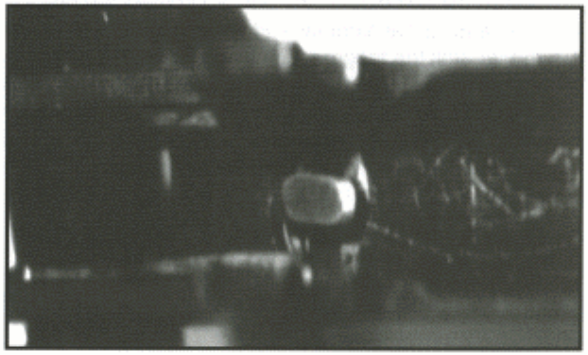
BLOCKING THE SEAR DISCONNECTOR

This "KEY" can easily be made at a reasonable cost in any good machine shop. The hole in the "KEY" is just an option and is only there for a key ring

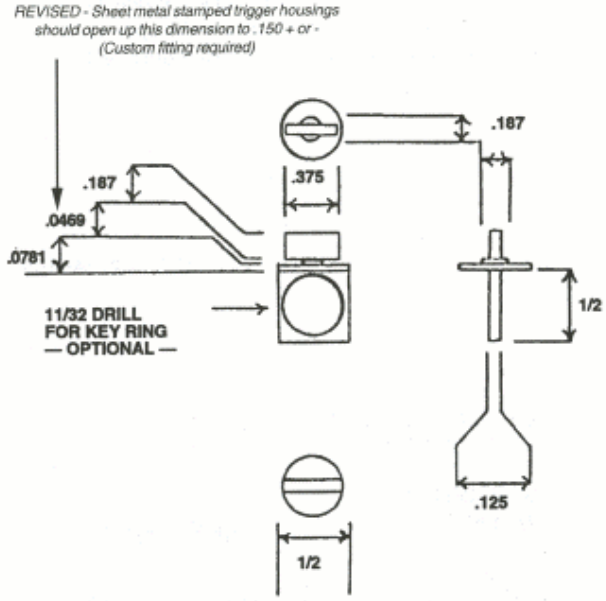
KEY REMOVED



KEY IN PLACE



The "key" will block the sear disconnector. This positively will not allow the sear disconnector to drop below the sear. The trigger will be in total control of the sear.



SKS KEY

.000 + or — .010
FRACTIONS + or — .015
NOT TO SCALE

An inexpensive alternative to the key could be to epoxy a thick shim under sear in milled bigger groups.

Although with this shim in place the rifle will fire automatically ONLY. With no semiautomatic option. As long as the trigger is squeezed the rifle will continue to fire. Releasing the trigger will stop the firing.

MATERIAL 1018 COLD ROLLED STEEL OR EQUAL

GLUE OR SCREW IN PLACE

SKS SHIM

.000 + or — .005
THREAD 2-B
NOT TO SCALE

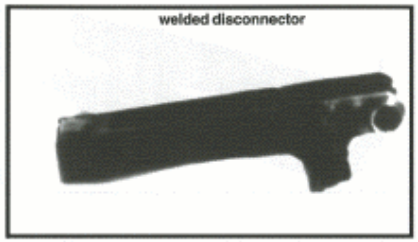
With the hammer modification only, the rifle is fully automatic only. The rifle must be returned to semiautomatics. This can be achieved by welding a cam onto the disconnector as shown in Fig. 4 Below.

CAUTION

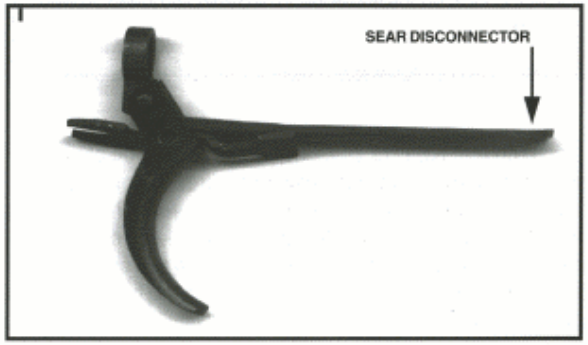
If the "key" were to be installed into a rifle without the hammer modifications, the hammer cam would break the sear disconnector on the first shot. This would obviously disable the gun.

With the "KEY" or shim inserted, the sear disconnector will be blocked, and not allowed to drop below the sear. The trigger will be in full command of the sear, thus making the rifle fully automatic. Removal of the "key" or shim will allow the sear disconnector to drop below the sear, releasing the sear to the rear to catch and hold the hammer, thus producing a semi-auto rifle once again.

A temporary alternative to welding the disconnector would be to use a good epoxy. Epoxy is very easy to shape and durable enough to do the job. It does have to be custom fit with a file to the proper thickness. With this modification the rifle would be restored to semi-auto fire.



Please note; however, that the manufacturing tolerances on the SKS are quite loose. The disconnector welds must be custom fit to each rifle, (filed or sandpapered)..



HAMMER

I would strongly recommend buying a spare hammer or better still an entire milled steel trigger group.

When buying a new trigger group be forewarned, some are made out of stamped sheet metal, they are usually very cheap but not recommended at all. The better choice would be to get the machined steel trigger housing, they are more expensive but definitely worth the extra money.

By only modifying the hammer it should be known that the rifle would fire automatically only with no semi-auto option. As long as the trigger is squeezed the rifle would continue to fire. Releasing the trigger would stop the firing.

The rifle would become a totally reliable select fire system by combining the modification of the hammer, the disconnector, and by blocking the sear disconnector with the "key" or shim.

When the key is inserted and turned 90 degrees the rifle would become fully automatic. Removal of the "key" would return the rifle to semi-auto.

NOTE: If a shim is used instead of the "key" the trigger group must be taken apart and the shim removed before the rifle would be semi automatic again.

I have now revealed three separate but interrelated methods.

1). With just the hammer modification fully automatic only, no semi automatic option. {See hammer blueprint on page 16).

2). The more complete and more reliable method requiring just a little more time would be to modify the hammer and the disconnector. With this method the rifle would be fully automatic only with the shim in place. Remove the shim and the rifle would once again be semi automatic. (See hammer blueprint on page 16, and shim blue print on page 20, and welded disconnector on page 22).

3). The much more complete and totally reliable system would be to combine all three methods, hammer disconnector, and the "KEY" to block the sear disconnector. With this method the rifle would be semi automatic without the "KEY". By inserting the key and turning it 90 degrees the rifle would be fully automatic. (See hammer blue print on pages 16, key blue print on page 19, and welded disconnector on page 22).

To explain the conversion sequence further, In Step 1) The Hammer modification, you learn how to convert your SKS to cycle fully automatically only. No semi auto fire, Squeeze the trigger and it will fire until you release the trigger or the magazine empties. All that's needed is a file.

In step 2) Disconnector modification, you'll learn to return your rifle to semi automatic again. So in step 1) you removed the disconnector cam (which acted on the bolt follower) from the hammer. In step 2 you are putting a raised cam on the Disconnector *so the disconnector will now trip the bolt follower* instead of the hammer.

Finally in step 3) you learned that ANYTHING you use to block the sear disconnector from dropping below the sear will cause full auto cycling. The "KEY" or the SHIM, a pop-cycle stick glued in place, anything that is 3/16" thick.

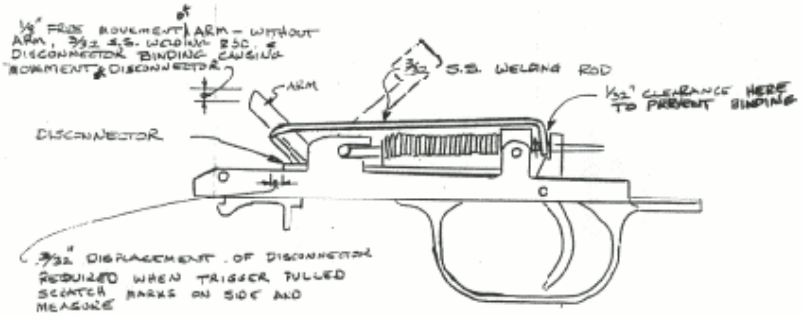
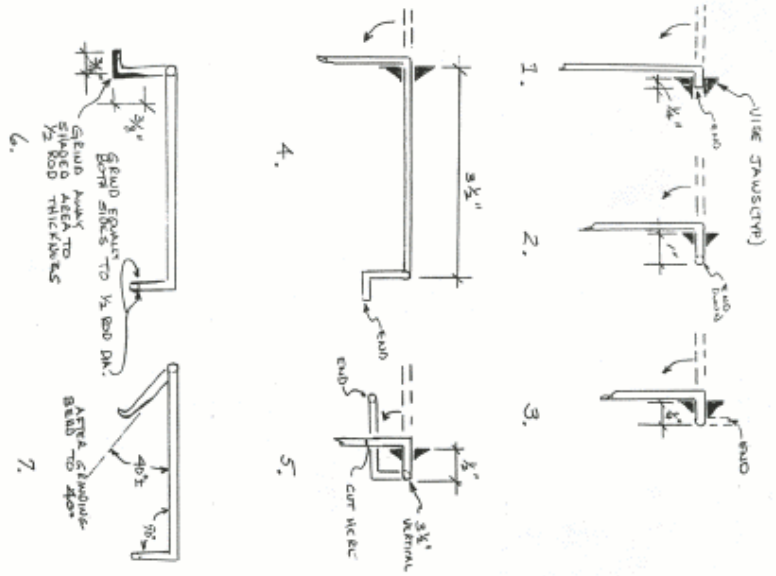
MINUTE - MAN FULL-AUTO CONVERSION

I can' take the credit for inventing the innovative design detailed on pages 28 and 29. It was given to me anomalously? This simple wire conversion method is definitely the easiest Full-Auto Conversion I have heard of yet for the SKS because it needs only a piece of 3 / 32" wire (welding rod) plus an hour or so of time for a reliable 'works every time' fitting. The generous "Minute - Man" who invented this slick little low cost wonder deserves some real credit. ***THANKS ALEXANDRIA, LOUISIANA!***

As you can see by the hand written and hand drawn graphics (Pages 28-29) I printed the exact pages as I received them, unfortunately this means I have no other information and because the inventor wisely wishes to remain unknown, sorry I can't get any photograph of the original prototype. This design is so basic that it must work plain and simple.

I would recommend you begin construction by using a 3 / 32" welding rod that is easily bent and shaped, at least until you are sure of the exact shape and position of your bends, then copy your test piece using a stainless steel welding rod due to stainless steels very high tensile strength. You'll soon see how dificult it is to bend wire to exact shapes and dimensions without a jig. Get as many extra soft steel "test rods" and stainless steel welding rods as you think your talents will require to become proficient at judging the exact positions, lengths, and radius of your bends.

WITH TRIGGER PULLED AND HELD, HAMMER IS HELD COCKED BY ARM – WITH BOLT LOCK UP ARM IS PUSHED DOWN TRIPPING RELEASE OF HAMMER. MINUTE ADJUSTMENT OF ROD MADE AT 90° ± 10° BEND. IF IT JUST AIN'T QUITE RIGHT BEND NEW ROD.


1/8" FREE MOVEMENT OF ARM – WITHOUT ARM, 3/32 ± S.S. WELDING ROD, DISCONNECTOR BINDING CAUSING MOVEMENT OF DISCONNECTOR
ARM
3/32
S.S. WELDING ROD
1/32" CLEARANCE HERE TO PREVENT BINDING
DISCONNECTOR
3/32" DISPLACEMENT OF DISCONNECTOR REQUIRED WHEN TRIGGER PULLED SCRATCH MARKS ON SIDE AID MEASURE

MINUTE-MAN CONVERSION